Work Order ID 126310 *126310* Page 1 Tuesday, November 04, 2014 1:52:57 PM Item ID: D3564-5 Accept *N900040100* Setup Start **Revision ID: Item Name:** Stop Stainless Steel Wearplate Center Aft **Start Date:** .. 11/4/2014 **Start Oty: 12.00** *19* **Cust Item ID: Required Date:** 11/4/2014 Req'd Qty: 12.00 *19* **Customer:** Reference: Run Process Plan: _MLJ Date: /Y-//-04 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Reject Reject Accept Insp. **Work Center ID** Description Run Hours Qty Qty Number Code Stamp **Draw Nbr Revision Nbr** D3564 Rev D 100 0.00 DAS FLOW WATER JET *100* 12 Waterjet 0.00 FLOW CNC Wateriet 1-Cut as per Dwg D3564 Dwg Rev: Prog Rev: 2-Deburr if necessary 304.063" 110 DAS QC2- Inspect parts off machine FAI/FAIB 0.00 23 *110* 9-89 14-11-9 12 QC 0.00 Memo Quality Control 120 QC8- Inspect parts - second check 0.00 DAS 38 9-89 OC

14-11-10

0.00

Memo

Quality Control

DQA:		_ Date:											DART
QA Closed:		Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UP		Wo	ork Order up	date only	AEROSPACE
Work Orde	ar.				DISPOSITION		·		AGAINST I	DEF	PARTMENT	PROCESS	
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NCR N	10				Suspected Unapproved		Large Fab Composite					_	
Root				Desci	ription of work order update		nitial	Actio			Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	_	Date	Verification	QC Inspector
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	Centre No	ot Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred	t [Temperature/Cure
	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Und	qualified [Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/Ur	nclear [Part Moved		Wrong Stock Pulled
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· [Turning Sequence				Finish		Out of 0	Calibration		•			
Ţ	Wave/Twist in Tube				Fit/Function		Out of	Sequence		•	<u> </u>		

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Item ID: Revision ID: Item Name:	D3564-5	el Wearplate Center Aft		Accept	*N900	004010	೧ *	Setup	Start Stop	*N:	S1*	
Start Date: Required Date Reference:	11/4/2014	Start Qty: 12.00 Req'd Qty: 12.00	*12 *12		Cust Item 1 Customer:				•	^IN;	S2*	
Approvals:		an:	Date:	Tooling: SPC (Y/N):		ate:ate:	-	Run	Start Stop	*NI *NI	R1*	
Sequence ID/ Work Center I 130 *120*	D	Operation Description NC BRAKE		Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code DAS 30	Accep Qty	ot Rej Qty		Reject Number	Insp. Stamp	 ,u\a)
Brake NC Brake NC		Memo Deburr if nec DT8155Form	essaryForm on Brake Joggle as per.Dwg.D	0.00 as per Dwg D3564 using Jig 3564 on brake using Jig DT8	s DT8179 and 3157	9-89						
¹⁴⁰ *1⊿∩*	g#.	QC5- Inspect part comple	teness to step on W/O	0.00			(13				DAS 38 9-8	}
QC Quality Control		Memo Ensure joggle	as per dwg D3429	0.00						10-1-1	NOV 2	
150 *1 \(\) Powdercoat		Grey Sandtex(Ref:4.3.5.6)	per OSI005 4.3	0.00			12	S	14-	12-4	/	\$ \$ \$

Powder Coating

DQA:		Date:	: <u></u>									TAART	
					WORK ORDER NON-	-CC	ONFO	RMANCE / UF				AEROSPACE	
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188	Cracks	-			Broken/Damage/Defect		Hardwa	are		Part Incorred	ct	Temperature/Cure	
	Crimp/Kink/Ripple/Wave			Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing	Weld		
	Cuffs			Contamination		Instruct	tions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled		
	Crush	_			Countersink		1	gned/off center	. L	Positioned V		-	
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Work Ord Tuesday, Noven			_	Page 3								
Item ID: Revision ID:	D3564-5			Accept	*N900	0040	110) *	Setup	Start	*N	S1*
Item Name:	Stainless Stee	el Wearplate Center Aft								Stop	*//	S2*
Start Date:	11/4/2014	Start Qty: 12.00	*12*		Cust Item	ID:						
Required Date: Reference:	11/4/2014	Req'd Qty: 12.00	*12*		Customer:							
Approvals:	Process Pl	an:	Date:	Tooling:	D	ate:		. 1	Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
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Quality Control	<u> </u>											DEC 0 5 201
170 *170*		Identify as per dwg & Sto	ck Location: F-6C	0.00				x 10	1		00/)	
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1 A \(\Pi\) QC Quality Control		Memo		0.00						/_	9/12	10 48

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Part N	lo.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
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	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	rt	Temperature/Cure
	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqu	ıalified	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	tions Incomplete/Unc	tlear	Part Moved		Wrong Stock Pulled
	Crushing				Countersink		Misali	gned/off center		Positioned V	/rong	-
	Heat Treat			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other	
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	Turning Sequence			Finish		Out of	Calibration					
	Wave/Twist in Tube				Fit/Function		Out of	Sequence				

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Picklist Print

Tuesday, November 04, 2014 1:52:59 PM

Work Order ID: 126310

126310

Parent Item:

D3564-5

D3564-5

Parent Item Name: Stainless Steel Wearplate Center Aft

Start Date: 11/4/2014

Required Date: 11/4/2014

Start Qty: 12.00

Required Qty: 12.00

Comments:

M304S16GA

IPP Rev:A

New Issue 07-03-08 ec

Purchased

IPP Rev:B

As per Rev C 07-07-09 JLM

IPP Rev:C

As per Rev D 07-09-09 JLM Verified By:EC

IPP Rev D

added DT# 08.04.21 DD Verified by EC

No

Component Item ID/ **Item Name**

Replacement Mfg/ Item ID Purch

Bin Primary

Item Location

Last

Location

Route Seq ID

100

Unit of Qty on Measure Hand

474.4886

Qty per Kit Total

**

Qty

19

1.5

Qty Issued

Date Status Issued

DAS 23

Page 1

9-89

M304S16GA

304/316 Sheet .063

Location Loc Qty Loc Code **MAT020** 361.0886 M127821 71.317 M129449 193.7716 M130745 96 TPI

M129545

113.4

113.4

sf

DQA:	-	Date:											***	DART
QA Closed:		Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UI		Vork Or	der up	date only	7	AEROSPACE
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DART AEROSPACE LTD	Work Order:	26310
Description: Wearshoe	Part Number:	D3564-5
Inspection Dwg: D3564 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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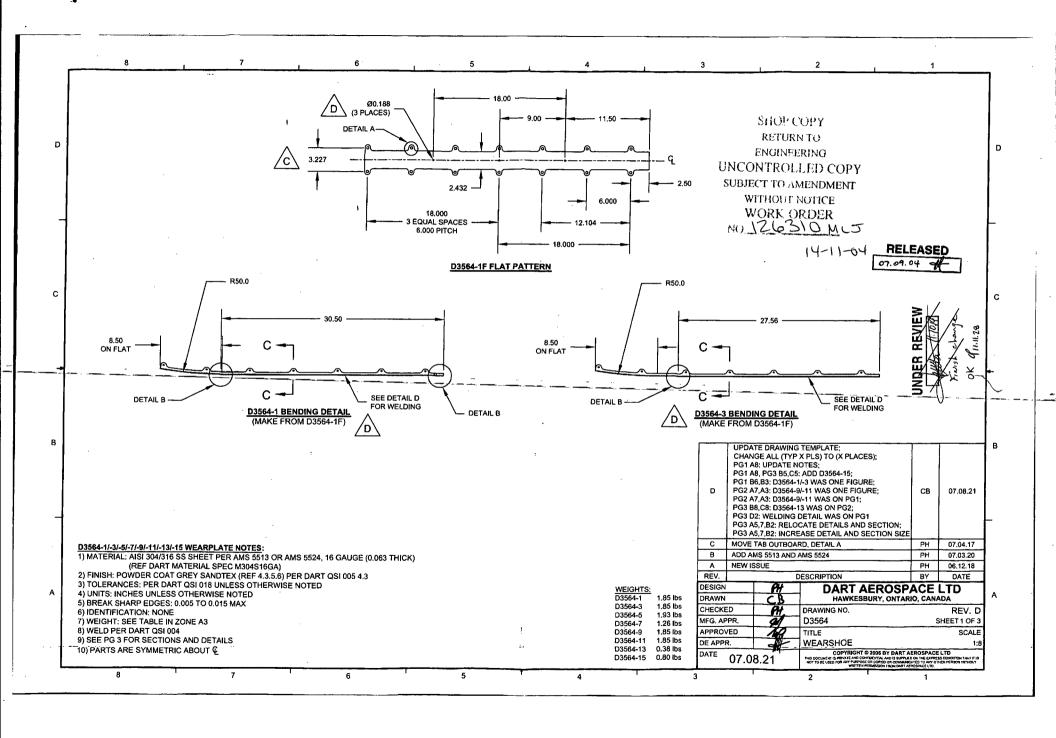
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Measured by: 23
9-89
Date: 14-11-9
Date: 14-11-10
DAS
Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
Α	08.01.16	New Issue	KJ/EC/DD	<i>D</i>

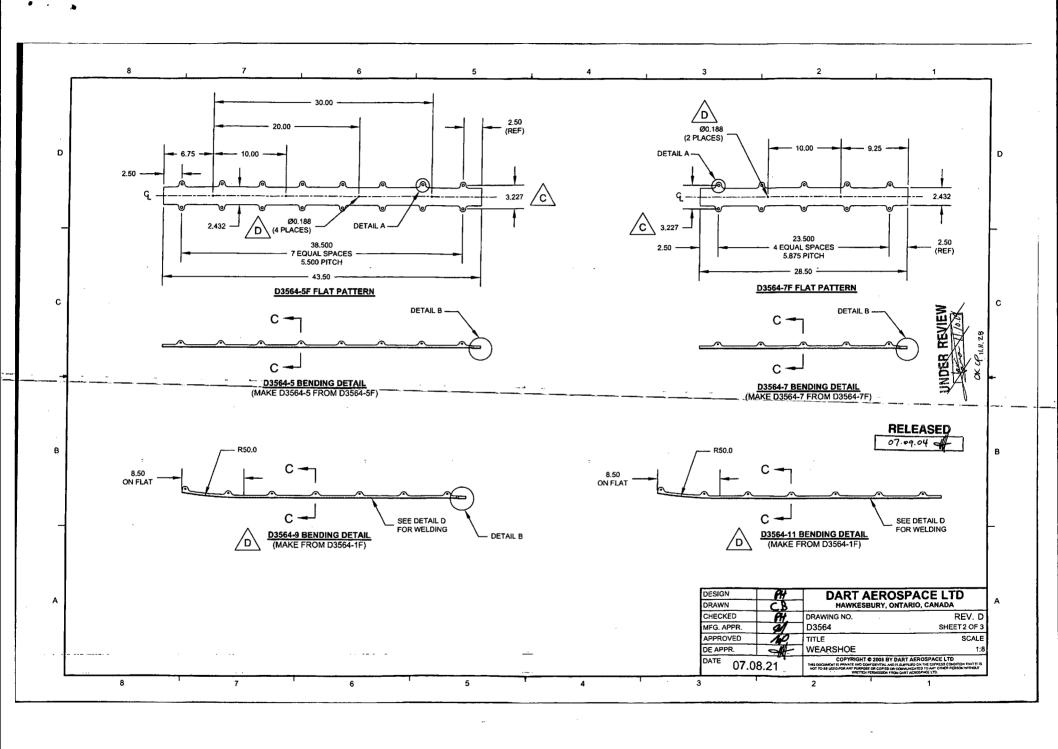
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Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
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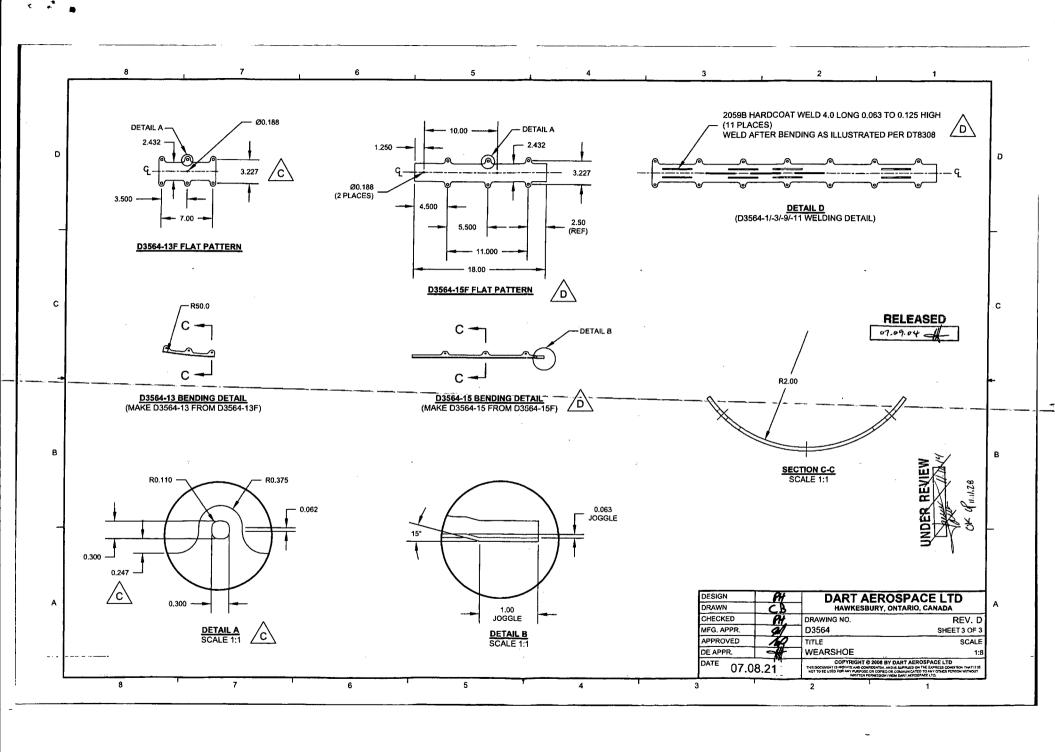


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Work Orde	r:				DISPOSITION				AGAINST	DEI	PARTMENT	PROCESS	
					Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	0.				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
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Wave/Twist in Tube				Fit/Function	Out of Sequence								

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DQA:		Date:											
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QA Closed:		Date:			Work Order update only								
Work Orde	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
			··· ··		Rework			Skid-tube	Crosstube			Water Jet	Engineering
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Ĺ	Cracks				Broken/Damage/Defect		Hardwa			Part Incorrect		Temperature/Cure	
	Crimp/Kir	ık/Ripple	/Wave		Burrs		Inspection Incomplete/Unqualified				Part Lost/Missing		Weld
_	Cuffs				Contamination	-	Instructions Incomplete/Unclear			-	Part Moved	L	Wrong Stock Pulled
	Crushing				Countersink	-	Misaligned/off center			-	Positioned Wrong		
1	Heat Trea				Cut Too Short		Mislabeled				Power Loss/	Surge	Other
	Inspection	٠.	Tube		Drawing		Misread						
_	Marks/Ch				Drill Holes	-	Off-set						
1	Turning S	•			Finish		Out of Calibration						
	Wave/Tw	ist in Tub	oe -		Fit/Function		Out of Sequence						



DQA:	QA: Date:													
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only									
Work Orde	r:	,		٠	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N	 				Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Crosstu Machining Small I Thermoforming Finish Large Fab Compos			Prod Rec/Stor	Engineering Quality Other			
Root				Desc	ription of work order update		nitial	Action		Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Waterial Deperator Offset/Setup Process Supplier Training Transport Unapproved			ž [*]							bier.				
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Landin	g Gear Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch Turning S	nk/Ripple it n Strip in natter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish	_	Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration			Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance et ssing /rong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other		
<u> </u>	Wave/Tw				Fit/Function	\vdash	1	Seguence						

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